



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

004479

D204-706-015
Job Sheet 180626



Part No: D204-706-015

Job Qty: 1 ea

Part Name: Fuel Purge Canister



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/11/18

Job Tracking No:

Due Date: 7/25/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:E 04.12.03 Remove AN6289-6D KJ/JLM IPP Rev:F 10.05.10 as per chg002 DD
verified :EC IPP Rev:G 12.12.07 as per IIN revB DD verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	1 Ea	7/25/18	7/25/18	0.00	0.00	Start Up Stores/Pkg-1		JUL 18 2018
110	Packaging	1 pcs	7/25/18	7/25/18	0.00	0.00	Packaging1-2		JUL 19 2018
120	QC	1 pcs	7/25/18	7/25/18	0.00	0.00	QC4		JUL 19 2018
125	DC	1 pcs	7/25/18	7/25/18	0.00	0.00	DC		JUL 19 2018
130	Packaging	1 pcs	7/25/18	7/25/18	0.00	0.00	Packaging3-1		JUL 20 2018
140	QC21-FG	1 Ea	7/25/18	7/25/18	0.00	0.00	QC21		JUL 20 2018

Part Op 125 - Photocopy bluefile and create labels per PPP D204-706-015 CHG003

Descriptions: 130 - Identify and pack for shipping as per PPPDD204-706-015 Location: _____ PPP Rev: _____ JUL 20 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-5A	Bolt	4 Ea (4 ea)	90-Start up Operation	5041106-1
AN814-6D	Plug	1 Ea (1 ea)	90-Start up Operation	FM137445
AN815-6D	Union M Flare	2 Ea (2 ea)	90-Start up Operation	5019415
AN816-6D	Nipple-M-6Flare -1/4NPT	1 Ea (1 ea)	90-Start up Operation	FM137988-70
AN833-6D	Elbow, Bulkhead-M-Flare	1 Ea (1 ea)	90-Start up Operation	5082932
AN919-6D	Reducer	1 Ea (1 ea)	90-Start up Operation	F16323
AN924-6D	Nut	1 Ea (1 ea)	90-Start up Operation	5034390
D2001-4	Valve Assembly 1/4 Inch	1 Ea (1 ea)	90-Start up Operation	5093095
D2026-101	Valve Mounting Screws	2 pcs (2 ea)	90-Start up Operation	735326
D3262-041	Canister Assembly	1 Ea (1 ea)	90-Start up Operation	F144996
D3264-1	Bracket	2 Ea (2 ea)	90-Start up Operation	5088974
D3297-5-0410	Hose Assembly	1 pcs (1 ea)	90-Start up Operation	F23292
D3298-011	Tube Assembly	1 pcs (1 ea)	90-Start up Operation	F23298
D3298-013	Tube Assembly	1 pcs (1 ea)	90-Start up Operation	F22047
D3298-015	Tube Assembly	1 pcs (1 ea)	90-Start up Operation	F23300
D3299-1	Fitting	1 Ea (1 ea)	90-Start up Operation	F144759
D3301-1	Placard	1 Ea (1 ea)	90-Start up Operation	5072186
D3301-3	Placard	1 Ea (1 ea)	90-Start up Operation	5092727
D3302-5	Doubler	1 pcs (1 ea)	90-Start up Operation	F22112
D3302-7	Doubler	2 pcs (2 ea)	90-Start up Operation	F23307
MS21042L3	Nut	4 Ea (4 ea)	90-Start up Operation	5078107
MS21919-WDG12	Clamp	1 Ea (1 ea)	90-Start up Operation	FM129630

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Dart Aerospace Ltd. 1270 Aberdeen Street Newbury, ON K6B 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartero.com www.dartaerospace.com Date: 07/18/18 Container No: S093255 Part: D204 - 706 - 015 Job No: 180626 Serial No/Batch: S093255 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____							
Root Cause DART AEROSPACE							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐			Inspection Incomplete/unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Wrong Stock Used ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____							

MS21919-WDG6	Clamp	FM129909-40	2 Ea (2 ea)	90-Start up Operation
MS21919-WDG7	Clamp		3 Ea (3 ea)	90-Start up Operation
MS21920-42	Clamp		2 Ea (2 ea)	90-Start up Operation
MS29512-06	O-Ring		5 pcs (5 ea)	90-Start up Operation
MS35489-11	Grommet		1 Ea (1 ea)	90-Start up Operation
NAS1149D0332J	Washer		2 Ea (2 ea)	90-Start up Operation
NAS1149D0363J	Washer		8 Ea (8 ea)	90-Start up Operation

5072454
5000373
5090794
5056030
FM129499-40
5035396
5015269

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-5A	4	190	0
	AN814-6D	1	8	0
	AN815-6D	2	28	0
	AN816-6D	1	3	0
	AN833-6D	1	12	0
	AN919-6D	1	13	0
	AN924-6D	1	26	0
	D2001-4	1	2	0
	D2026-101	2	47	0
	D3262-041	1	3	0
	D3264-1	2	9	0
	D3297-5-0410	1	4	0
	D3298-011	1	10	0
	D3298-013	1	6	0
	D3298-015	1	5	0
	D3299-1	1	8	0
	D3301-1	1	14	0
	D3301-3	1	0	0
	D3302-5	1	5	0
	D3302-7	2	14	0
	MS21042L3	4	1,922	0
	MS21919-WDG12	1	29	0
	MS21919-WDG6	2	10	0
	MS21919-WDG7	3	16	0
	MS21920-42	2	2	0
	MS29512-06	5	120	0
	MS35489-11	1	11	0
	NAS1149D0332J	2	1,505	0
	NAS1149D0363J	8	1,444	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

REFERENCE ONLY

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
	X		D205-706-013	FUEL PURGE CANISTER INSTALLATION (205/214/EAGLE SINGLE)
		X	D204-706-015	FUEL PURGE CANISTER INSTALLATION (204)
1	1	1	D2001-4	VALVE ASSEMBLY
		2	D2026-101	SCREW
	1	1	D3262-041	CANISTER ASSEMBLY
1			D3262-043	CANISTER ASSEMBLY
2	2	2	D3264-1	BRACKET
1			D3297-1-0098	HOSE ASSEMBLY
1	1		D3297-1-0121	HOSE ASSEMBLY
	1		D3297-1-0130	HOSE ASSEMBLY
1			D3297-3-0210	HOSE ASSEMBLY
	1		D3297-3-0350	HOSE ASSEMBLY
		1	D3297-5-0410	HOSE ASSEMBLY
	1		D3298-001	TUBE ASSEMBLY
1			D3298-005	TUBE ASSEMBLY
1			D3298-007	TUBE ASSEMBLY
	1		D3298-009	TUBE ASSEMBLY
		1	D3298-011	TUBE ASSEMBLY
		1	D3298-013	TUBE ASSEMBLY
		1	D3298-015	TUBE ASSEMBLY
	1	1	D3299-1	FITTING
1	1		D3299-3	FITTING
1			D3299-5	FITTING
1			D3299-7	FITTING
1	1	1	D3301-1	PLACARD
1	1	1	D3301-3	PLACARD
1	1		D3302-1	DOUBLER
1	1		D3302-3	DOUBLER
		1	D3302-5	DOUBLER
		2	D3302-7	DOUBLER
2			D3329-1	BUSHING
1			D4054-001	TUBE ASSEMBLY
1			D4054-003	TUBE ASSEMBLY
1			D4054-009	TUBE ASSEMBLY
4	4	4	AN3-5A	BOLT
	1	1	AN814-6D	PLUG
1			AN814-8D	PLUG
2	2	2	AN815-6D	UNION
1			AN815-8D	UNION
		1	AN816-6D	NIPPLE
2	3	1	AN833-6D	ELBOW

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Revision: B

Date: 12.11.06

REFERENCE ONLY

Kim Johnston

From: Sonia Quirion
Sent: Wednesday, July 18, 2018 12:55 PM
To: Kim Johnston
Subject: I/b

D204-706-015
S093255
x1

Change Record

PAGE 1 OF 1

Part Number: D204-706-015

Description: FUEL PURGE CANISTER

[illegible]